



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3015
Job Sheet 181381



Part No: 646.3015

Job Qty: 50 ea

Part Name: Blade



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/C SHEET 12 IPP REV:A NEW ISSUE 12/11/09 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea	9/10/18	9/10/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	50 pcs	9/10/18	9/10/18	0.00	0.78	Bandsaw1		DAS 54 9-89
110	CNC Vertical Machining	50 pcs	9/10/18	9/10/18	0.18	62.74	HAAS1-1		
120	QC	50 pcs	9/10/18	9/10/18	0.00	0.00	QC2 Machining-1		
130	QC	50 pcs	9/10/18	9/10/18	0.00	0.00	QC8 Machining-1		
140	Outsource	50 pcs	9/10/18	9/10/18			MEI001-VC	15	18-08-29
150	Packaging	50 pcs	9/10/18	9/10/18	0.00	0.00	Packaging2		SEP 12 2018
155	QC	50 pcs	9/10/18	9/10/18	0.00	0.00	QC6		61 9-89
160	SprayPaint	50 pcs	9/10/18	9/10/18	0.00	1.62	Spray Paint		DAS 38 9-89
170	QC	50 pcs	9/10/18	9/10/18	0.00	0.00	QC14		
180	Packaging	50 pcs	9/10/18	9/10/18	0.00	0.00	Packaging3-1		OCT 23 2018
190	QC21-SA	50 Ea	9/10/18	9/10/18	0.00	0.00	QC21		OCT 23 2018

Part Op 100 - Cut Blank at 6.580"

Descriptions: 110 - 1-Machine per folio FB150

140 - FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS As per dwg 646.3000 PART ARE MADE FROM AISI A2 TOOL STEEL DETAIL OF C OF C REQUIRED → P0040913 - Meteor

160 - PRIME AS PER DWG, SEE NOTE #4

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

outsourcing P10:041263

DAS 13 9-89

OCT 04 2018

OCT 09 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MSTEEL-A2-B0.500X1.250	AISI A2 Tool Steel Bar, 0.500 X 1.250	27.4500 ft (.549 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MSTEEL-A2-B0.500X1.250	27	8	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Blade	0.375inches ± 0.005	0.380 0.370		
2	Blade	0.177inches	0.182	Diameter	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Completed/Improved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																		
Date : _____		MRB (QSI042) Approval _____																																																																																																																																		
Description _____		Completed By _____																																																																																																																																		
		Lead hand / Supervisor Approval Verification _____																																																																																																																																		
		QC / QA Coordinator Approval _____																																																																																																																																		
		 Container No: S105905 Part: 646.3015 Job No: 181381 Serial No/Batch: S105905 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 08/28/18																																																																																																																																		
Root Cause <table border="1" style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td><td>No Re-ve</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Se</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table> <table border="1" style="width:100%; border-collapse: collapse;"> <tr><td>☐</td><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td><td>Positioned Wrong</td></tr> <tr><td>☐</td><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Inspection Incomplete/Unqualified</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Outside Dimensions</td></tr> <tr><td>☐</td><td>Cuffs</td><td>☐</td><td>Contamination</td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Over/Under tolerance</td></tr> <tr><td>☐</td><td>Crushing</td><td>☐</td><td>Countersink</td><td>☐</td><td>Off-set</td><td>☐</td><td>Part Incorrect</td></tr> <tr><td>☐</td><td>Heat Treat</td><td>☐</td><td>Cut Too Short</td><td>☐</td><td>Mislabeled</td><td>☐</td><td>Part Lost/Missing</td></tr> <tr><td>☐</td><td>Wave/Twist in Tube</td><td>☐</td><td>Instructions Incomplete/Unclear</td><td>☐</td><td>Fit/Function</td><td>☐</td><td>Part Moved</td></tr> <tr><td>☐</td><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td><td>Misaligned/off center</td><td>☐</td><td>Drawing</td></tr> <tr><td>☐</td><td colspan="3"></td><td>☐</td><td></td><td>☐</td><td>Finish</td></tr> <tr><td>☐</td><td colspan="3"></td><td>☐</td><td></td><td>☐</td><td>Misread</td></tr> <tr><td>☐</td><td colspan="3"></td><td>☐</td><td></td><td>☐</td><td>Turning Sequence</td></tr> </table>					Environment	☐	No Re-ve	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Se	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Positioned Wrong	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Outside Dimensions	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Over/Under tolerance	☐	Crushing	☐	Countersink	☐	Off-set	☐	Part Incorrect	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Part Lost/Missing	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Part Moved	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Drawing	☐				☐		☐	Finish	☐				☐		☐	Misread	☐				☐		☐	Turning Sequence
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		+ 0.005	0.177	
		- 0.000		
3	Blade	0.940inches ± 0.010	0.950 0.930	
4	Blade	0.524inches ± 0.005	0.529 0.519	
5	Blade	0.240inches ± 0.020	0.260 0.220	
6	Blade	0.125inches ± 0.005	0.130 0.120	Radius
7	Blade	45.000Degrees ± 0.500	45.500 44.500	
8	Blade	0.524inches ± 0.005	0.529 0.519	
9	Blade	0.690inches ± 0.002	0.692 0.688	
10	Blade	1.250inches ± 0.002	1.252 1.248	
11	Blade	4.684inches ± 0.005	4.689 4.679	
12	Blade	6.450inches ± 0.010	6.460 6.440	
13	Blade	0.325inches ± 0.005	0.330 0.320	
14	Blade	30.000Degrees ± 0.500	30.500 29.500	

Plex 7/26/18 7:52 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040913**

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO040913
PO Date: 9/4/18
Due Date: 9/14/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181381	646.3015	Blade FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS As per dwg 646.3000 PART ARE MADE FROM AISI A2 TOOL STEEL DETAIL OF C OF C REQUIRED	Firmed	-	9/14/18	50 pcs	0 pcs	50 pcs	\$5.20/pcs	\$260.00

50 x

SEP 12 2018

Grand Total: \$260.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/12/18 3:53 PM dart.tsimiklis.chrisoula

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
330145	1	130691

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
40913		A2	2018/9/4	FED

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
50	646.3015	(50) 646.3015 JOB 181381		21,45

1 BOITE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

CERTIFICAT

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 50
POIDS EXPÉDIÉ / Weight Shipped : 21,45
QUANTITÉ RESTANTE / Quantity Remaining : 0
POIDS RESTANT / Weight Remaining : 0,00

APPROUVÉ

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped:	50
POIDS EXPÉDIÉ / Weight Shipped :	21,45

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2018/09/10

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
330145	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
40913 ✓	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ processing specifications

VAC HARDEN

HARDEN AND TEMPER

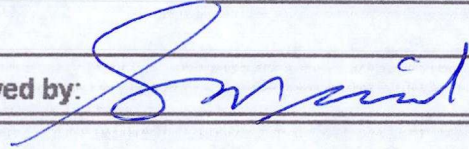
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	5	61 - 62 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
✓ 50	21,45	646.3015 ✓ (50) 646.3015 JOB 181381 ✓ 1 BOITE DE CARTON

21/9/18

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2018-09-09

APPROUVÉ

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détail

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
330145	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
40913	N/A	A2		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC	5	61 - 62 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
50	21.45	646.3015 (50) 646.3015 JOB 181381 1 BOITE DE CARTON		

COMMENTAIRES / comments

VAC HARDEN 1800F, 1HR 30MIN
DOUBLE TEMPER 400F, 2HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous vous signalons qu'il est strictement interdit de les divulguer, de les reproduire ou d'en utiliser de quelque manière que ce soit le contenu. Toute exportation ou réexportation non autorisée est interdite.

APPROUVÉ par / Approved by:

Vincent Constant



DATE: 2018-09-12

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-JACQUES, QC, J7R 5A8

Tél: 450-475-7834

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450-491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
330145	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

ON K6A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
40913	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	5	61 - 62 HRC

QUANTITÉ POIDS DESCRIPTION DES PIÈCES

quantity	weight	parts description
50	21,45	646 3015
		(50) 646.3015
		JOB 181381
		1 BOITE DE CARTON

2/19/18

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2018-09-09





Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041263**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO041263

PO Date: 10/4/18

Due Date: 10/5/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181381	646.3015	Blade	Firmed	-	10/5/18	50 pcs	0 pcs	50 pcs	\$10.00/pcs	\$500.00
2	182625	647.4311	RH Lower Strut	Firmed	-	10/5/18	10 pcs	0 pcs	10 pcs	\$10.00/pcs	\$100.00
3	181423	646.9711	Blade	Firmed	-	10/5/18	120 pcs	0 pcs	120 pcs	\$10.00/pcs	\$1,200.00
4	179157	646.3511	Strut	Firmed	-	10/5/18	12 pcs	0 pcs	12 pcs	\$10.00/pcs	\$120.00
5	179156	646.3510	Strut	Firmed	-	10/5/18	12 pcs	0 pcs	12 pcs	\$10.00/pcs	\$120.00
Grand Total:										\$2,040.00	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

[Signature]

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